

Date: Tuesday, 11/14/2006 10:03:51 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FLOOR PROTCTOR AFT LH
<b>Job Number</b> :	29426	<b>Part Number</b> :	D32813
<b>Estimate Number</b> :	11228	<b>Drawing Number</b> :	D3281 REV B
<b>P.O. Number</b> :	N/A	<b>Project Number</b> :	N/A
<b>This Issue</b> :	11/14/2006	<b>Drawing Revision</b> :	B
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	N/A
<b>First Issue</b> :	N/A	<b>Due Date</b> :	12/20/2006
<b>Previous Run</b> :	27510	<b>Qty:</b>	10
<b>Written By</b> :	<b>Um:</b> Each		
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev:A 04.07.01 New issue KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0 PG

PURCHASING



Comment: PURCHASING

Issue P/O: 2495

Description: Floor Protector Aft, LH

Possible Supplier: Delastek

Certificate of Conformity is required

C20611115

(10)

2.0

D32813P

Floor Protector, Aft LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
 Floor Protector Aft, LH

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure certificate of conformity is attached

P 7/6/22 (10)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

P 07/6/23 (10)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPP B29418

P 7/6/23 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 07/01/24

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:03:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCOR AFT LH

Job Number: 29426

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(18)

Comment: FINAL INSPECTION/W/O RELEASE

207/11/24

Job Completion



U 07/11/24

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

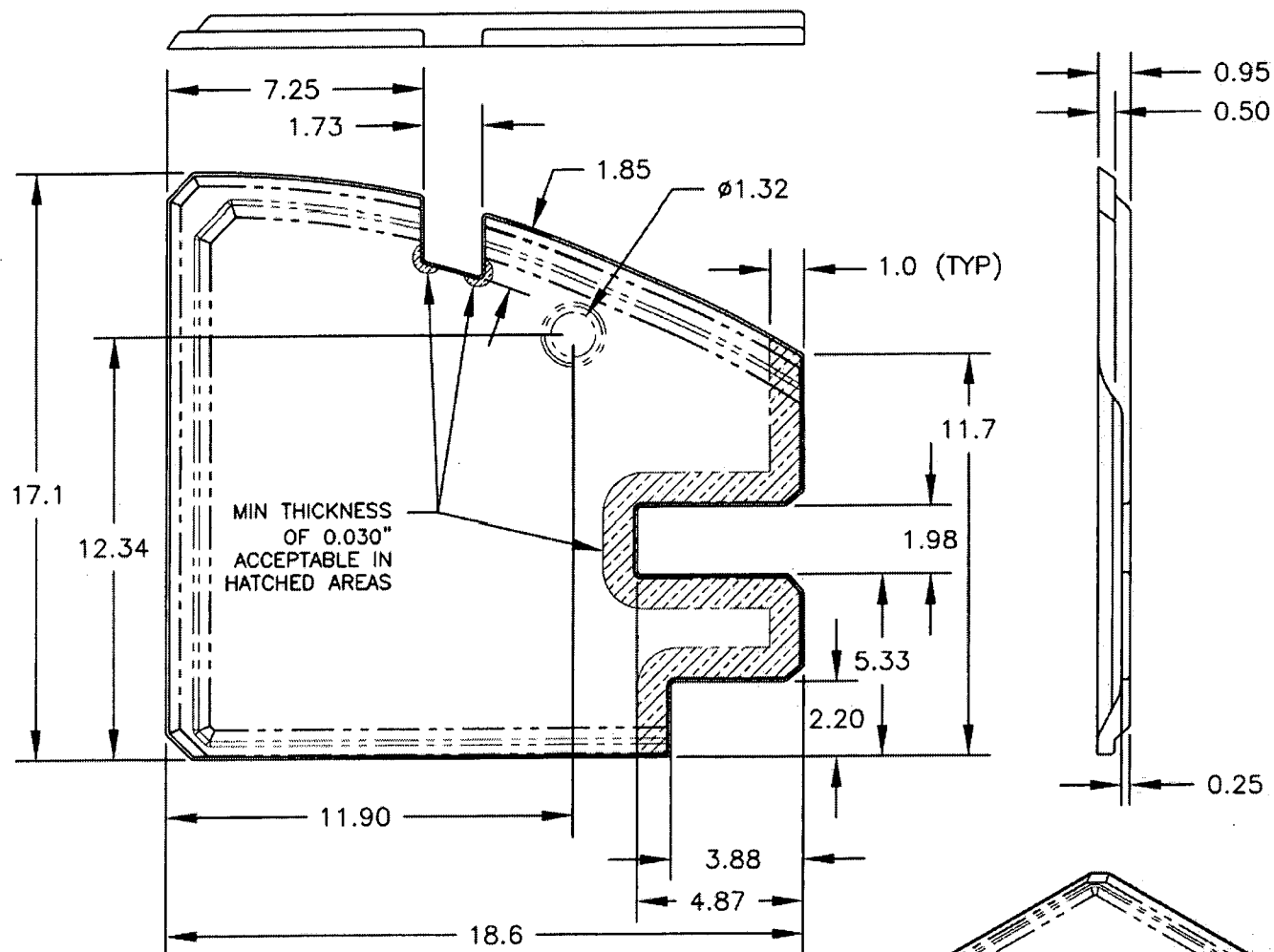
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	

**RELEASED**  
05.12.01**D3281-1 FLOOR PROTECTOR, FWD LH**

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

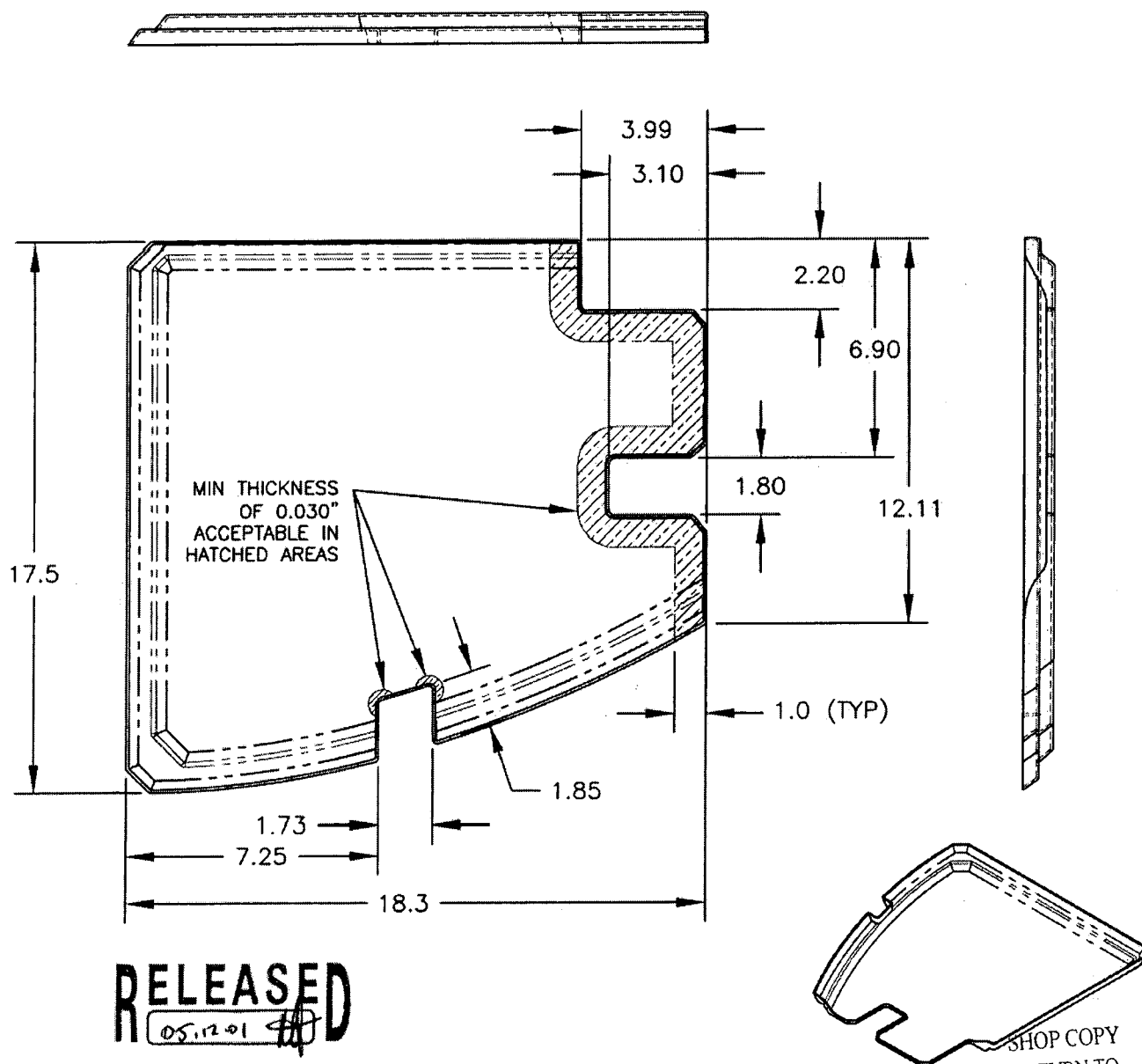
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NO. 29426

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CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**D3281-2 FLOOR PROTECTOR. FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

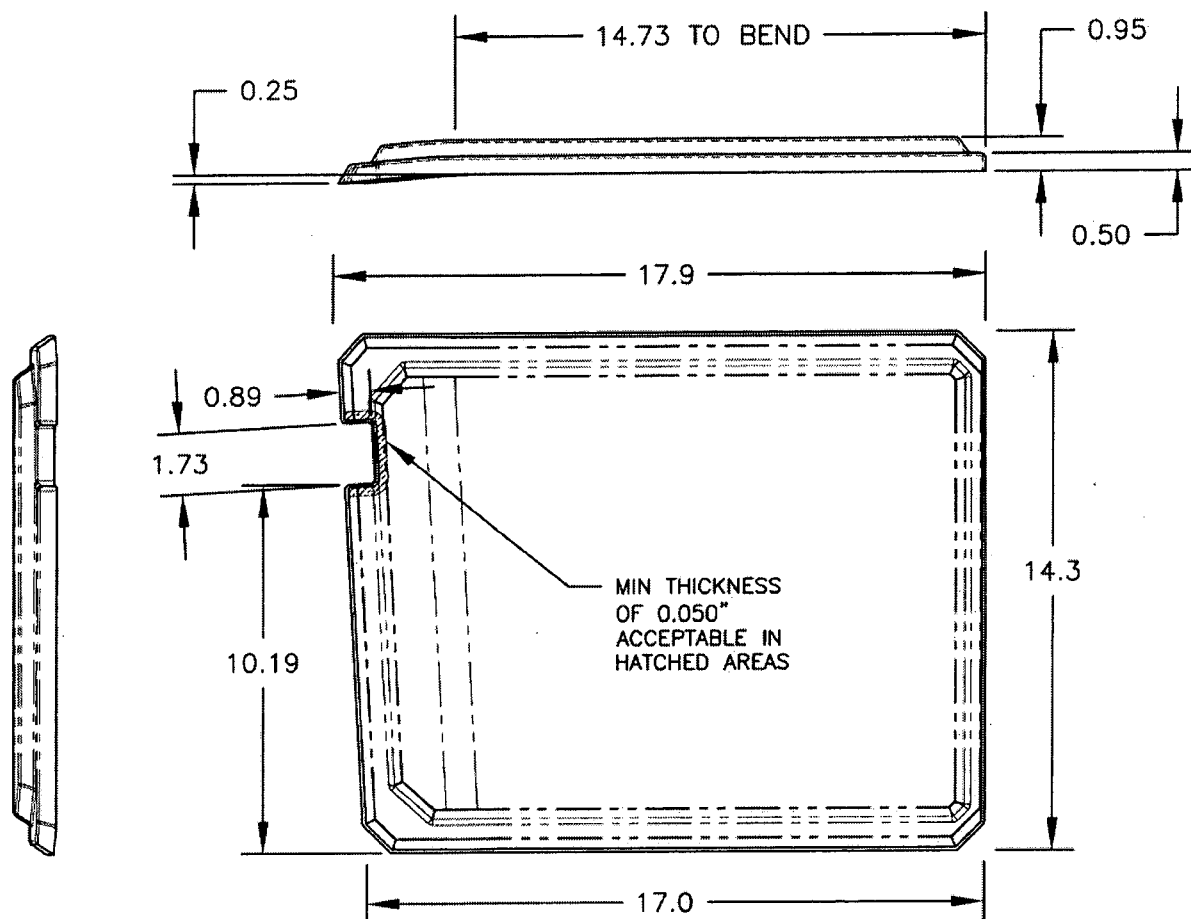
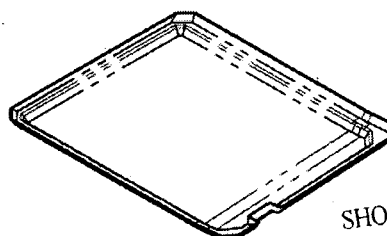
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CHECKED <i>ll</i>	APPROVED <i>ll</i>	DRAWING NO. D3281	REV. 8 SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**  
05.12.01. *ll*

**D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)**  
**D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2  
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DELASTEK COMPOSITES INC.  
2699, Sième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11497
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
19/01/07	15/11/06	5017	C. Lavoie		PO0002495		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
10	0	10	DKC134-0044	Floor Protect Part 1 N° D3281-1 ( F6006 ) B29424 Selon dessin D3281 Rev.: B Job: 40353 U de M : Each			
10	0	10	DKC134-0046	Floor Protect Part 3 N° D3281-3 ( F6006 ) B29426 Selon dessin D3281 Rev.: B Job: 40356 U de M : Each			
10	0	10	DKC134-0047	Floor Protect Part 4 N° D3281-4 ( F6006 ) B29427 Selon dessin D3281 Rev.: B Job: 40357 U de M : Each			


07/01/23

07/01/23

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

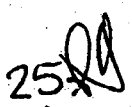
Accepted by:

  
Quality department AQ-357



Site: Jeudi, 2006-11-16 15:06:30  
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : FLOOR PROTECTOR AFT, LH	
Numéro Job : 40356		Numéro Article : DKC134-0046	
Numéro Soumission : 2385		Numéro Dessin : D3281	
Numéro B.A. :		Projet Numéro : DKC134	
Cette fois : 2006-11-16	No. B.V. :	Révision dessin : B	
Dernière Rev. : NC		Matériel : F6006	
Rem. fois : -	Type :	Date Dûe : 2006-12-08	Qté: 25 
Objet précédente : 36894			UdM: UNITE
Écrit par :			
Écrit & Approuvé par :			
Commentaires :	N° de pièce: D3281-3		

Process Sheet Rév.: 01 Inverser le rang de la séquence d'inspection et d'identification

Produit additionnel

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

1.0 APL0016

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentaire Qty.: 0.167 UNITE(s)/Unit Tc  
Lexan F6006 Noir N° 700 48" x 96"

APL0016



3-5913-1

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

N° de Lot:

# Bon achat: 5913

2.0 SÉCHAGE/ANEAL

SÉCHAGE / ANEALING



Commentaire Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.5000Hrs  
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.  
Inscrire sur la carte de température le numéro de Job du matériel au séchage.  
# de cuisson: 5483 75484

3.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 45.0000Hrs  
TAILLAGE DU MATÉRIEL

Faire le tailage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 25 Date: 10-1-07 Sceau:

Quantité: Date: Sceau:



## Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.  
Numéro Job: 40356

Nom Dessin: FLOOR PROTECTOR AFT, LH  
Numéro Article: DKC134-0046

Numéro Job:



# Séq.: Machine ou Opération: Description :


4.0 THERMOFORMAGE2 THERMOFORMAGE DES PIÈCE DART



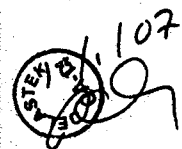
Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 2.5000Hrs  
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-3 à l'aide du moule N° D3281-3T1 sur le  
thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 25 Date: 10-1-07 Sceau: 

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

F.O. 

5.0 TRIMAGE 3 TRIMAGE COMPOSITES DART

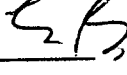


Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 2.5000Hrs  
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-3 à l'aide du gabarit de trimage N° D3281-3T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 25 Date: 11-1-07 Sceau: 

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

6.0 IDENTIFICATION4 IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs  
IDENTIFICATION PIÈCES DART


Faire l'identification des pièces à l'aide des informations suivantes:

N° de pièce: D3281-3

N° de Job: 40356

Date de fabrication: 15-1-07

Sceau d'inspection.

Quantité: 25 Date: 15-1-07 Sceau: 

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

ate: Jeudi, 2006-11-16 15:06:30  
utilisateur: Sylvie Hamel

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40356

Nom Dessin: FLOOR PROTECTOR AFT, LH  
Numéro Article: DKC134-0046

Numéro Job:



# Séq.: Machine ou Opération: Description :

7.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs  
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 25

Date: 18-01-07

Sceau:

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs  
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton  
identifiée comme suit:

N° de pièce: D3281-3

Date de fabrication: \_\_\_\_\_

N° de job: \_\_\_\_\_

Quantité: 25

Date: 18/1/07

Sceau:

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_